

Date: Thursday, 2/14/2008 11:42:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 37412		
Estimate Number	: 10774		
P.O. Number	:	Part Number	: D3414041
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D3414 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 2/14/2008 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37375	Material	:
Written By	:	Due Date	: 2/21/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>08 02 14</u>		
Comment	: Est A 05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S12GA	304/316 .100" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.1523 sf(s)/Unit Total : 3.0450 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: 105130 LB 8-2-20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3414

Dwg Rev: A LB 8-2-20

Prog Rev: A

2-Deburr if necessary LB 8-2-20

(24)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



LB 8-2-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



08 02 20 (24)
counted



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form using DT8254 as per Dwg D3414

08 03 04 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

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Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/13/04 (P 24)

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D3414-3 Lug

A/R SS Rod

3 43705 = 18x.
M. 116115

SP 09.02.12.

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

SP 09.02.12 18x.

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.02.12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 02/12 (18)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 109996

SP 09-02-23 (18)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 09/02/23 (18)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

462

D 3414041
1337412
23/02/2009
S.044 14.50
#1 401.2 F
#2 30m 113 F
#3 30m 113 F
#4 ---- F

9/2/24

(18)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 37412

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR
09-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

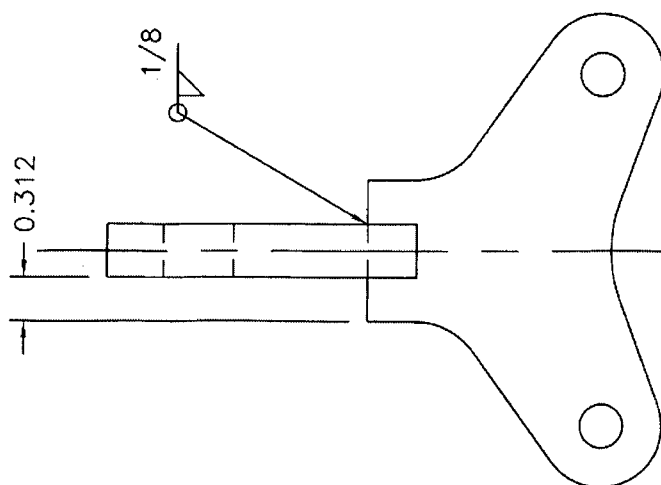
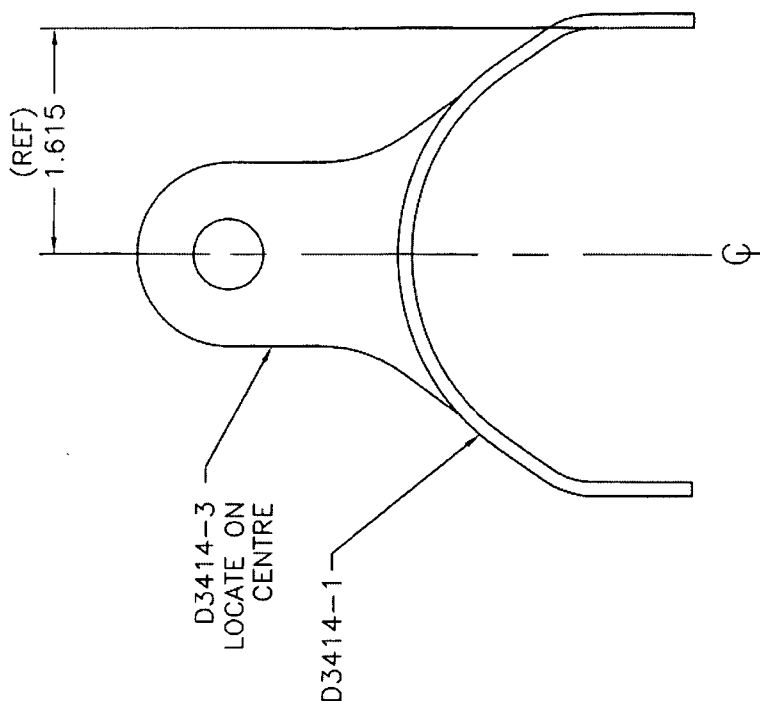
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

05.04.06 *[Signature]*



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WORK ORDER
NO 37412

D3414-041 LUG ASSEMBLY

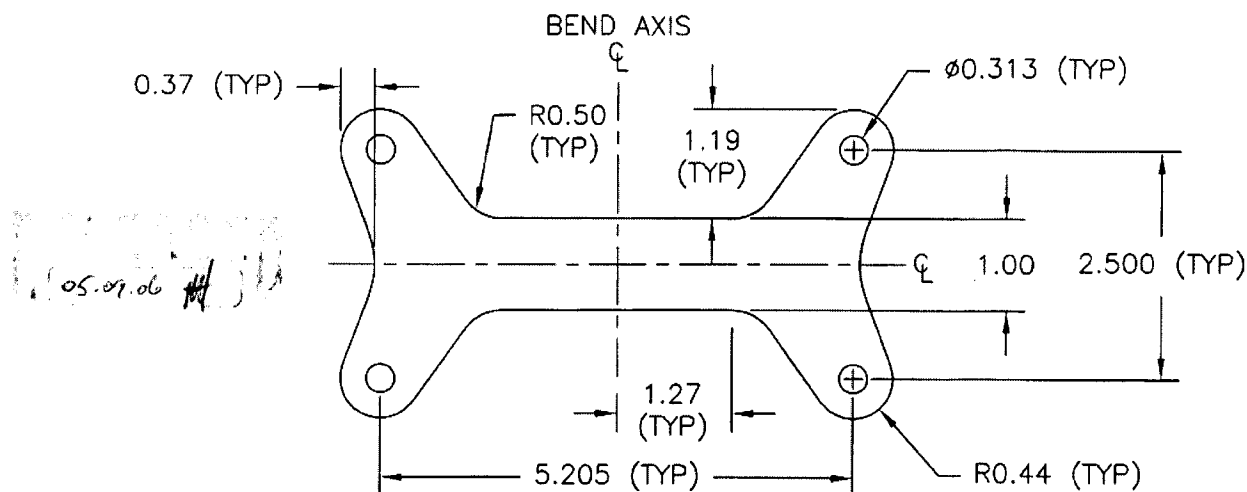
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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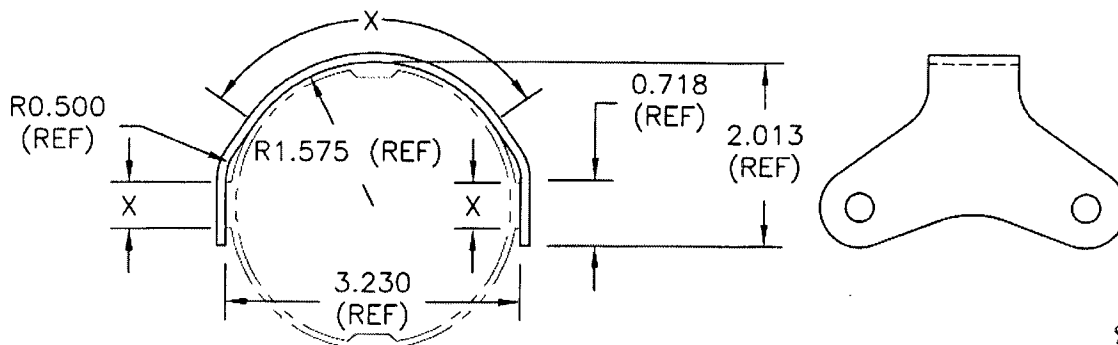
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:2

**D3414-1 FLAT PATTERN**

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)

**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

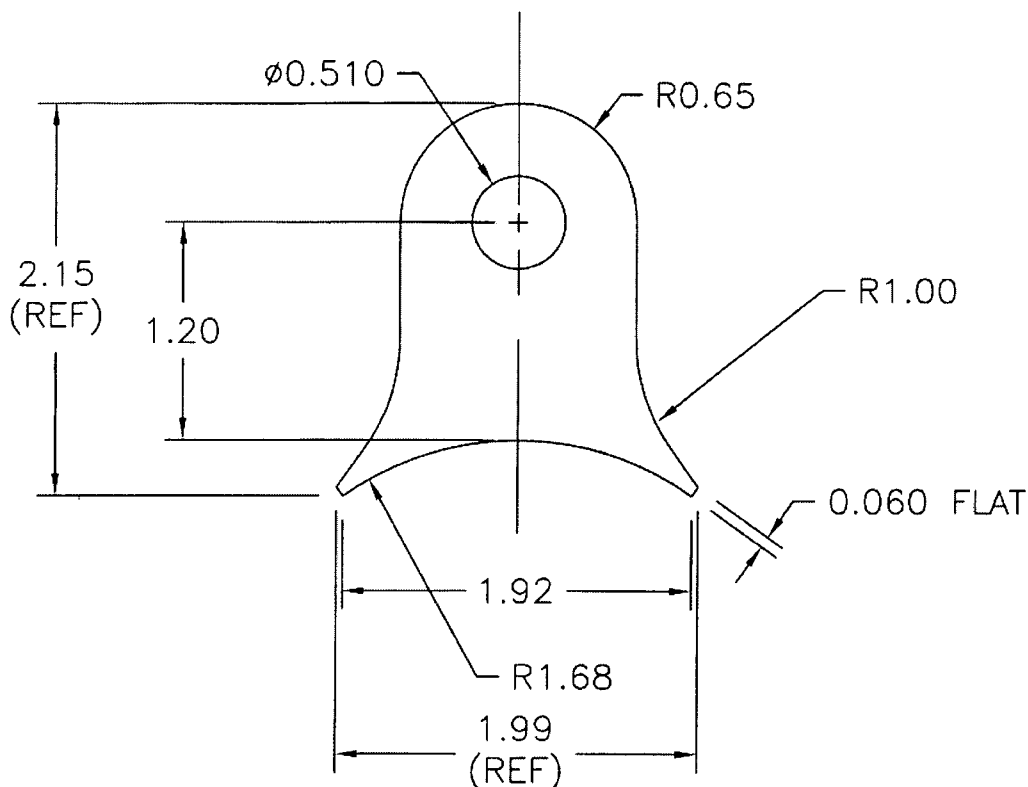
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1



D3414-3 LUG

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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